

PLA

Process Sheet

PRELIMINARY ISSUE

Date: Tuesday, 30/01/2007 11:04:52 AM
User: Linda Lacelle

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR DOUBLER	
Job Number	: 30496		Part Number	: D35943	
Estimate Number	: 12681		Drawing Number	: D3594 UNDER REVIEW	
P.O. Number	:		Project Number	: N/A	
This Issue	: 30/01/2007	S.O. No. :	Drawing Revision	: U/R	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 31/01/2007	Qty: 2 Um: Each
Previous Run	:				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev :A New Issue 07-01-22 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 1.0710 sf(s) 6061-T6 .080 Sheet	
	X Batch: M102448	ml 07 01 30	(2)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3594. Dwg Rev: U/R Prog Rev: U/R	ml 07 01 30 (2)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ml 07 01 30 (2)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	ml 07 01 30 (2)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	ml 07 01 30 (2)
		Deburr if necessary.	

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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07.01.30

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/01/30 ①

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/01/30

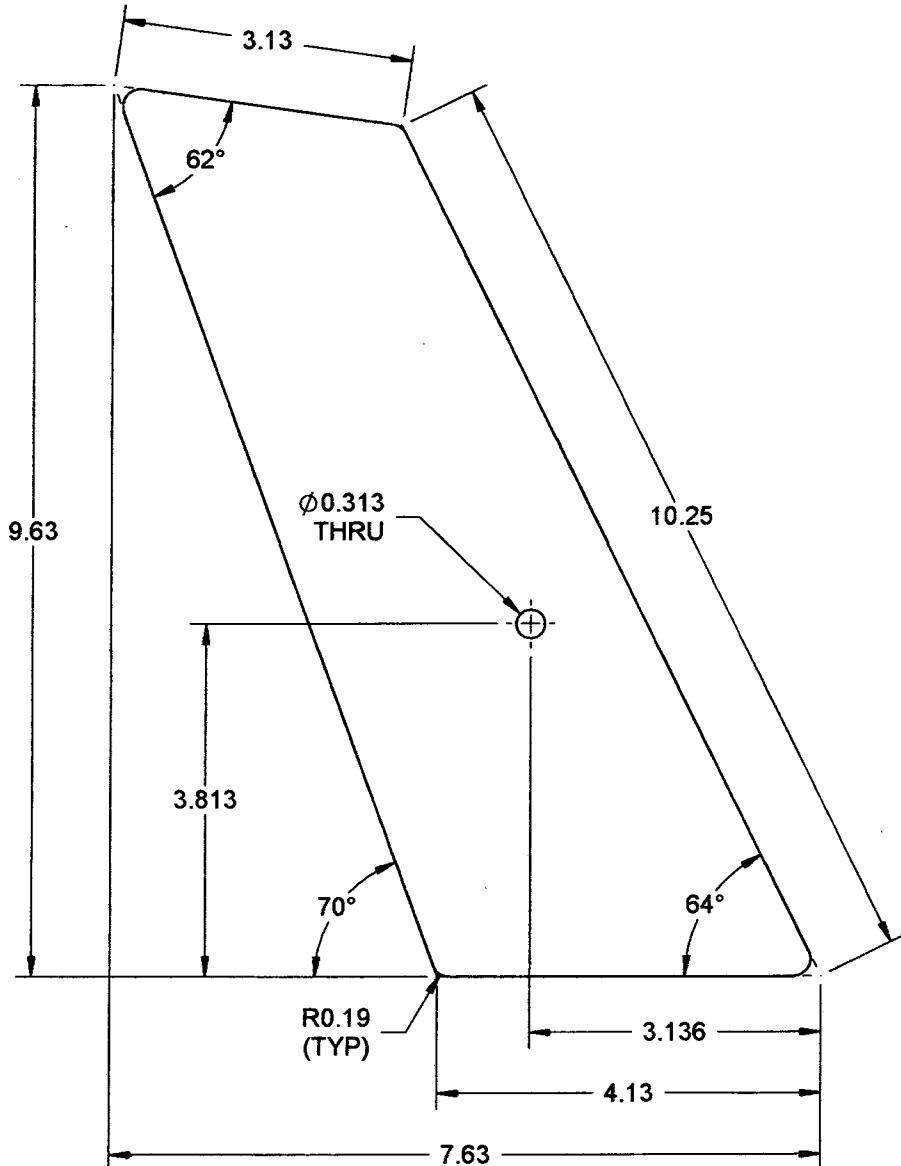
Job Completion



07.01.30

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3594	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE FLOOR DOUBLER	SCALE 1:2	



D3594-3 FLOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	30496
Description: Door Doubler	Part Number:	D3594-3
Inspection Dwg: D3594 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	M.M.	Audited by:	E	Prototype Approval:	
Date:	07.01.30	Date:	07.01.30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	